

Work Order ID 80627

February-24-12 3:19:50 PM

80627

Page 1

Item ID: D4006-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Channel
 Start Date: 24/02/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 09/03/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: M.C.S Date: 12/02/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D4006 | A | | | | | | | | |

100 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg
 2024.063 Dwg Rev: A
 Prog Rev: A
 2-Deburr if necessary

B12-3-5

(10)

110 0.00
110
 QC Memo 0.00
 Quality Control

B12-3-5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 80627

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Page 2

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Item ID: D4006-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Channel
 Start Date: 24/02/2012 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 09/03/2012 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|---------------------------------|
| 120 *120* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | | | | | | 5/26/05 (HE) |
| 130 *130* Brake NC Brake NC | Bend as per dwg Memo C'sink as per dwg | 0.00 0.00 | | | | | | | Sp 12/03/06 |
| 150 *150* HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | | | | 12/03/06 (S) 11 12/03/07 x18 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 3

Item ID: D4006-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Channel
 Start Date: 24/02/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 09/03/2012 Req'd Qty: 8.00 ***8*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|-----------|--------------|---------------|---------------|------------------|----------------|
| 160 *160* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | Scrub log | | (7/6) | | | |
| 170 *170* Packaging Packaging | Identify as per dwg & Stock Location: <u>GA</u> Memo | 0.00 0.00 | | | | | | | |
| 180 *180* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | |

Handwritten: 12/23/08 (18)

Handwritten: 12/3/08

Handwritten: 12-03-8

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

February-24-12 3:19:54 PM

Page 1

Work Order ID: 80627

80627

Parent Item: D4006-3

D4006-3

Parent Item Name: Channel

Start Date: 24/02/2012

Required Date: 09/03/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP rev A 09.12.22 new Issue Prelim EC verified by:DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M2024T3S.063 | | Purchased | No | | | 100 | sf | 183.5000 | 0.0971 | 0.817684 | | | |

M2024T3S 063

**

B12-3-5

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

183.5

119916

183.5

117018

117018

18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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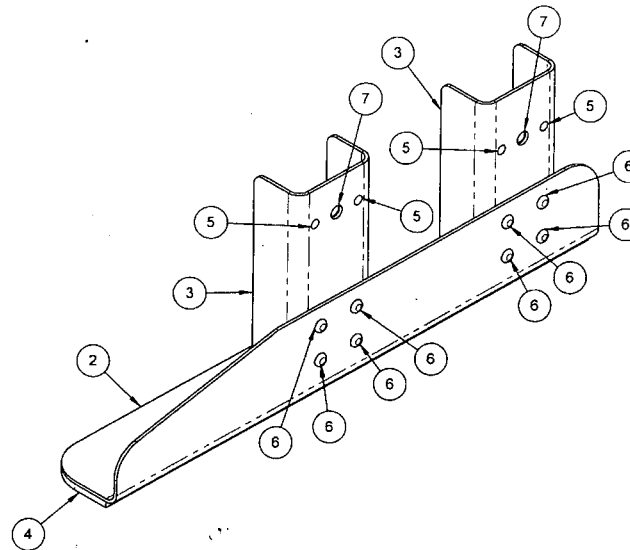
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NOTE: Date & initial all entries

| ITEM NO. | QTY. -041 | PART NUMBER | DESCRIPTION | JOHN CAMERON AVIATION PART NUMBER |
|----------|--------------|--------------|---------------------------|--------------------------------------|
| 1 | X | D4006-041 | TANK TOP SUPPORT ASSEMBLY | JCA-M47-2-01 |
| 2 | 1 | D4006-1 | ANGLE | |
| 3 | 2 | D4006-3 | CHANNEL | |
| 4 | 1 | D4006-5 | FOAM | |
| 5 | 4 | MS20426AD3-4 | RIVET | |
| 6 | 8 | MS20470AD4 | RIVET | |
| 7 | 2 | MS21059-4 | ANCHOR NUT | |



D4006-041 TANK TOP SUPPORT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
BEFORE INSTALLATION OF D4006-5 FOAM AND MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4006-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.47 lbs

UNCONTROLLED
SUBJECT TO CHANGE
WITHOUT NOTICE

NO. 80627 H.C.J.
12/02/27

RELEASED
R 2010-05-05 D

| | | | |
|------------|-------------|------|----------|
| A | NEW ISSUE | BY | 10.02.05 |
| REV. | DESCRIPTION | DATE | |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.02.05 | | |

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|--|------------------------|
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWING NO. D4006 | REV. A SHEET 1 OF 6 |
| TITLE UPPER RESTRAINT | SCALE NTS |
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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

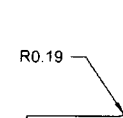
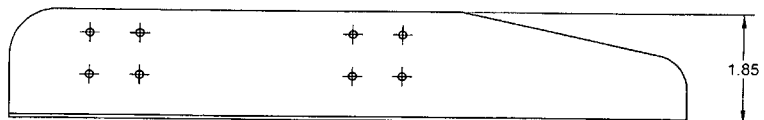
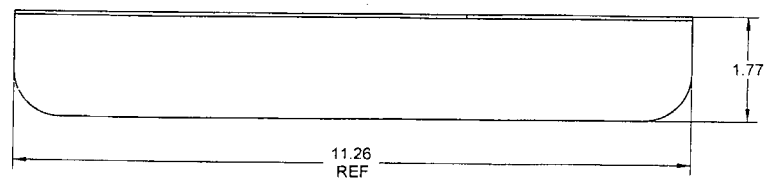
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

80027

| DART AEROSPACE PART NUMBER | JOHN CAMERON AVIATION PART NUMBER |
|-------------------------------|--------------------------------------|
| D4006-1 | REF JCA-M47-2-01 |



D4006-1 ANGLE

RELEASED
2010-05-05
MP

NOTES:

- 1) MATERIAL: MADE FROM D4006-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D4006 | SHEET 2 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | UPPER RESTRAINT | NTS |
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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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7

6

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4

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1

D

D

C

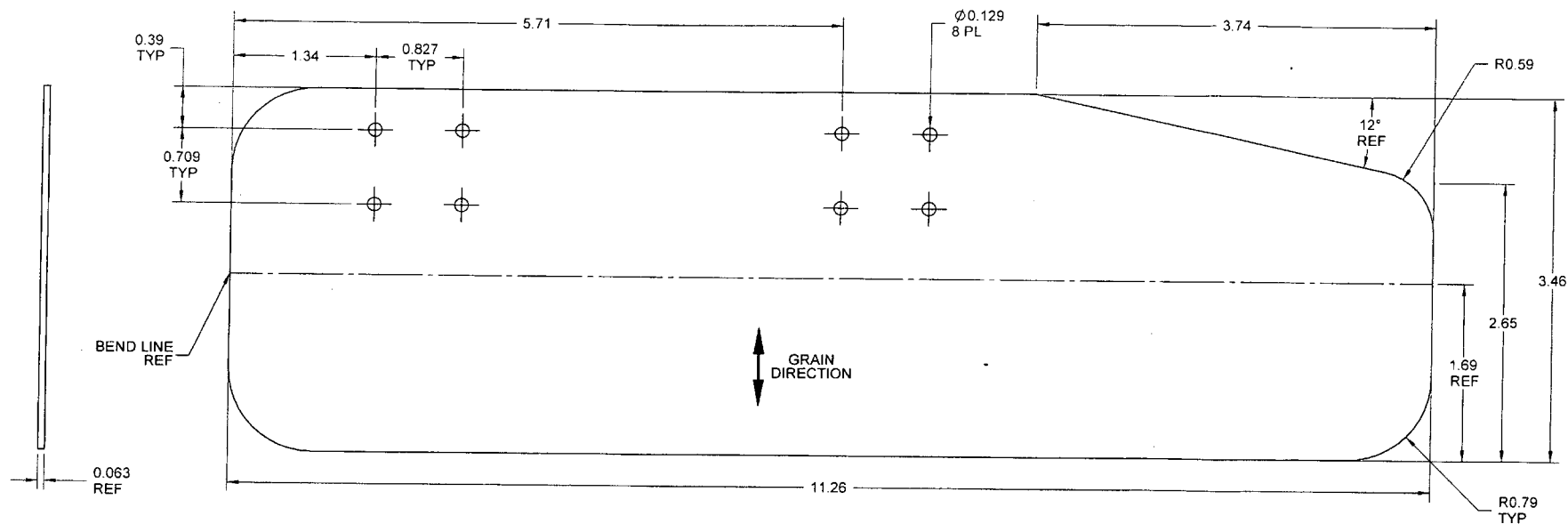
C

B

B

A

A









D4006-1F FLAT PATTERN

RELEASED
 2010-05-05
 MP

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
 PER QQ-A-250/4 OR AMS-QQ-A-250/4
 OR AMS 4037 OR ASTM B209
 REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

| | | | |
|---|---|--|--------------|
| DESIGN |  | DART AEROSPACE LTD | |
| DRAWN |  | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. A |
| MFG. APPR. |  | D4006 | SHEET 3 OF 6 |
| APPROVED |  | TITLE | SCALE |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

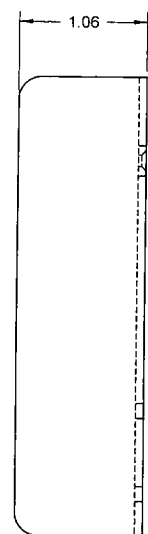
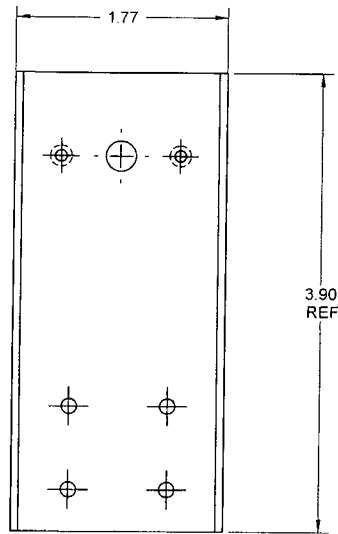
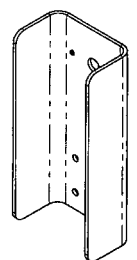
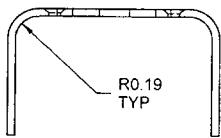
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NOTE: Date & initial all entries

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| DART AEROSPACE PART NUMBER | JOHN CAMERON AVIATION PART NUMBER |
|-------------------------------|--------------------------------------|
| D4006-3 | REF JCA-M47-2-01 |



D4006-3 CHANNEL

RELEASED
2010-05-05
MP

- NOTES:
- 1) MATERIAL: MADE FROM D4006-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

| | | |
|------------|----------|---|
| DESIGN | 1 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4006 TITLE UPPER RESTRAINT SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |
| DRAWN | 1 | |
| CHECKED | 1 | |
| MFG. APPR. | 1 | |
| APPROVED | 1 | |
| DE APPR. | 1 | |
| DATE | 10.02.05 | |

SHEET 4 OF 6

| W/O: | | WORK ORDER CHANGES | | | | | |
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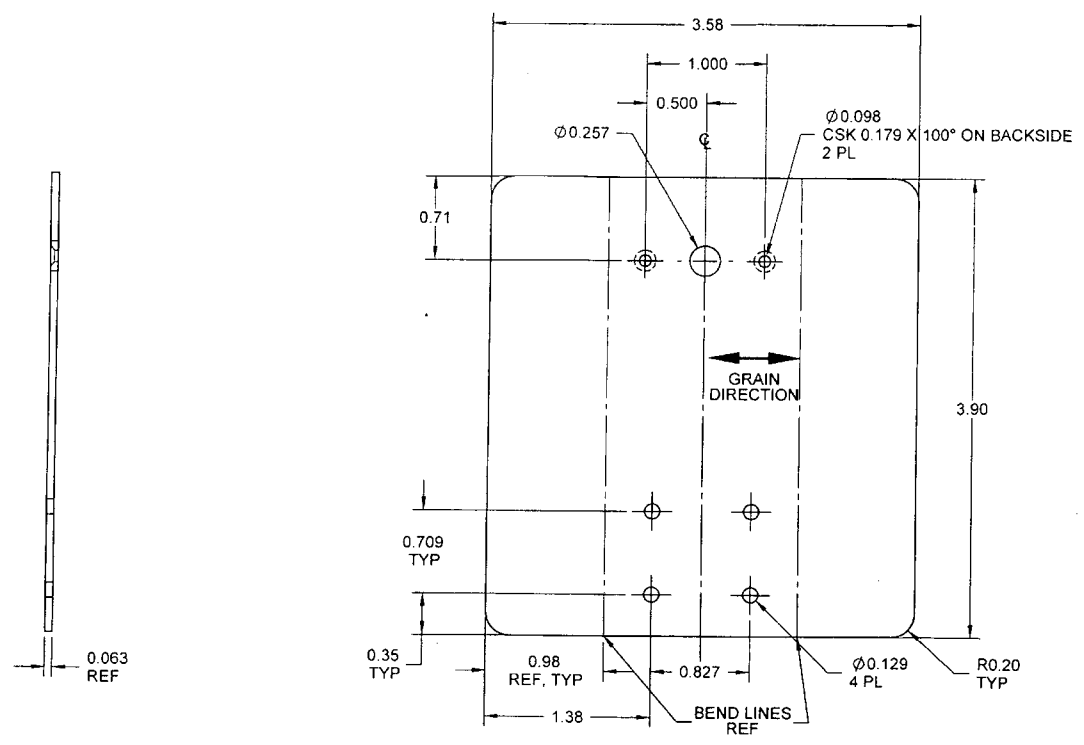
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NOTE: Date & initial all entries

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D4006-3F FLAT PATTERN

RELEASED
2010-05-05
md

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

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| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
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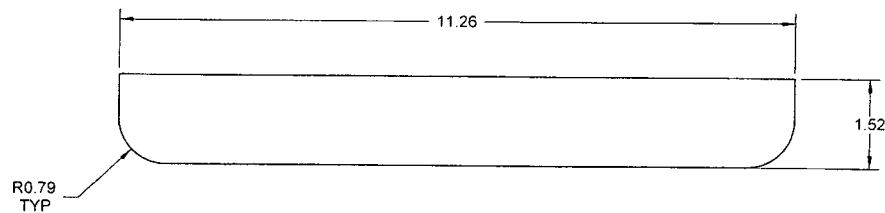
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NOTE: Date & initial all entries

80627

| DART AEROSPACE PART NUMBER | JOHN CAMERON AVIATION PART NUMBER |
|-------------------------------|--------------------------------------|
| D4006-5 | REF JCA-M47-2-01 |



D4006-5 FOAM

RELEASED
2010-05-05
MD

NOTES:

- 1) MATERIAL: BLACK NEOPRENE/EPDM/SBR BLEND SHEET, 0.125 THICK
PER ASTM D 1056 GRADE 2A1 OR SAE J-18 GRADE 2A1
REF DART SPEC M-4111N-S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

| | | |
|------------|----------|--|
| DESIGN | | DART AEROSPACE LTD |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. REV. A |
| MFG. APPR. | | D4006 SHEET 6 OF 6 |
| APPROVED | | TITLE SCALE |
| DE APPR. | | UPPER RESTRAINT NTS |
| DATE | 10.02.05 | COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries